

# Work Order ID 77357

**\*77357\***

Page 1

December-06-11 10:28:36 AM

Item ID: D350-591-312 Accept **\*N900040100\*** Setup Start **\*NS1\***  
 Revision ID: Stop **\*NS2\***  
 Item Name: Heli-Access-Step, Long RH  
 Start Date: 06/12/2011 Start Qty: 5.00 **\*5\*** Cust Item ID:  
 Required Date: 30/01/2012 Req'd Qty: 5.00 **\*5\*** Customer:  
 Reference:

Approvals: Process Plan: M.L.S Date: 11/12/06 Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start **\*NR1\***  
 QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D3272	Rev B

100  
**\*100\***  
 DC  
 Document Control

DOCUMENT CONTROL CP 0.00  
 Memo 0.00  
 Photocopy bluefile and type labels as per PPP D350-591-312 CHG001 5 12/11/06 Joh MLS 12-1-11 (5)

110  
**\*110\***  
 Large Fab  
 Large Fab

Large Fab 0.00  
 Memo 0.00  
 1-Bevel end for welding FWD ONLY  
 2-Weld Support using Jig DT8719, weld Fwd End Plate as per QSI 004 & Dwg D3272  
 A/R Aluminum Rod 114514  
119712  
 3-Grind End Plate flush

112.01.03 5 φ

**77357..5 X. R.H.**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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**NOTE:** Date & initial all entries

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**\*N900040100\***

Setup Start \*NS1\*

Stop \*NS2\*

**Cust Item ID:**

**\*5\***

**\*5\***

**Customer:**

**Reference:**

Run Start \*NR1\*

Stop \*NR2\*

**Insp.  
Stamp**

0.00

**\*120\***

QC

## Memo

0.00

## Quality Control

0.00

**\*130\***

OC

## Memo

0.00

## Quality Control

0.00

**\*140\***

HandFinish

## Memo

0.00

## Hand Finishing

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Revision ID:

Item Name: Heli-Access-Step, Long RH

Stop **\*NS2\***

Start Date: 06/12/2011 Start Qty: 5.00

**\*5\***

Cust Item ID:

Required Date: 30/01/2012 Req'd Qty: 5.00

**\*5\***

Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start **\*NR1\***

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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150 QC3- Inspect Part Finish

0.00

**\*150\***

QC Memo

0.00

Quality Control

5 RH of 12/01/06  
COUNT & MEASURED

180 Large Fab

0.00

**\*180\***

Large Fab Memo

0.00

Large Fab

1-Assemble Leg Assembly as per Dwg D3272.

2-Leave one rivet out until welding is complete.

3-Bevel Aft end for welding

4-Inspect for foreign object as per QSI 024

5-Weld Aft End Plate as per QSI 004 & Dwg D3272  
A/RAluminum Rod 114514

6-Grind End Plate flush

7-Install last rivet as per Dwg.

x5  $\phi$

→ Ae 12/01/06

12.01.06

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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**\*N900040100\***

Setup Start \*NS1\*

Stop \*NS2\*

**\*5\***

**\*5\***

**Reference:**

Run Start \*NR1\*

Stop **\*NR2\***

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

190 QC10- Inspect visual per QSI004- ground welds

0.00

0.00

**\*190\***

QC

## Memo

## Quality Control

200 QC5- Inspect part completeness to step on W/O

0.00

0.00

**\*200\***

QC

## Memo

## Quality Control

210 Chemical Conversion Coat per QSI005 4.1

0.00

0.00

**\*210\***

### HandFinish

## Memo

## Hand Finishing

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Item Name: Heli-Access-Step, Long RH

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Start Date: 06/12/2011 Start Qty: 5.00

**\*5\***

Cust Item ID:

Required Date: 30/01/2012 Req'd Qty: 5.00

**\*5\***

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Stop **\*NR2\***

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220 White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum 0.00

**\*220\***

Powdercoat

Powder Coating

Memo 0.00

START TIME: 2:45

OVEN TEMPERATURE: 320°F

FINISH TIME: 3:15

5X0 M/L 12/01/16  
RH

230 Wing Walk as per dwg QSI005 4.4 Batch 100105 0.00

**\*230\***

HandFinish

Hand Finishing

Memo 0.00

5 BL 12-1-17

240 QC3- Inspect Part Finish 0.00

**\*240\***

QC

Quality Control

Memo 0.00

5RH & 9L 12/01/12  
COUNT & MEASURED

M119460

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Required Date: 30/01/2012 Req'd Qty: 5.00

**\*5\***

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Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start **\*NR1\***

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
250	Pick Kit	0.00							
<b>*250*</b>									
Packaging	Memo	0.00							
Packaging									
260	QC4- 100% Inspect kits for completeness	0.00							
<b>*260*</b>									
QC	Memo	0.00							
Quality Control									
270	Packaging	0.00							
<b>*270*</b>									
Packaging	Memo	0.00							
Packaging	Identify and pack for shipping as per PPPD350-591-312								
	Location: <u>      </u>								

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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Revision ID:

Stop **\*NS2\***

Item Name: Heli-Access-Step, Long RH

Start Date: 06/12/2011 Start Qty: 5.00

**\*5\***

Cust Item ID:

Required Date: 30/01/2012 Req'd Qty: 5.00

**\*5\***

Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start **\*NR1\***

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
280	QC21- Final Inspection - Work Order Release	0.00							
<b>*280*</b>									
QC	Memo	0.00							
Quality Control									

12-01-19  
(5)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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**\*77357\***

**\*D350-591-312\***

**Required Date:** 30/01/2012

**Required Qty: 5.00**

IPP Rev:A04.03.22New issue KJ/RF

IPP Rev:B    07-06-09    Added D3572-1    JLM

IPP Rev:C 08-04-02 ECN1163 DD verified by:EC

IPP Rev:D 08-04-08 ECN1164 DD verified by:ec IPP Rev:D

fixe route seq in bom DD 10.04.28 verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3272-1		Manufactured	No			110	Each	20.0000	1	5			
*D3272-1*													
Step													
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				WA	B77360			5					
					76038			20					
					76039			10					
								10					
D3067-1		Manufactured	No			110	Each	125.0000	1	5			
*D3067-1*													
End Plate													
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				WA016				125					
					67582			2					
					68214			1					
					75468			32					
					76179			90					
D3219-1		Manufactured	No			110	Each	106.0000	2	10			
*D3219-1*													
Plate													
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				WA016	77674			106					
					73410			34					
					76226			72					

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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Work Order ID: 77357

**\*77357\***

Parent Item: D350-591-312

**\*D350-591-312\***

Parent Item Name: Heli-Access-Step, Long RH

Start Date: 06/12/2011

Required Date: 30/01/2012

Start Qty: 5.00

Required Qty: 5.00

D3066-1 Manufactured No

180 Each 148.0000 2 10

**\*D3066-1\***

Spacer

\*\*

*Ac 12/01/06*

Location

Loc Qty

Loc Code

WA015

148

75076

48

76180

100

*X10*

MS20600-AD4W4 Purchased No

180 Each 2,362.000 16 80

**\*MS20600-AD4W4\***

Rivets

\*\*

*B 119883*

*Ac 12.01.06*

Location

Loc Qty

Loc Code

ST321

2357

116188

59

117364

253

117601

200

117885

195

118840

1150

119860

500

WA018

5

116712

5

*80*

D3065-041 Manufactured No

180 Each 33.0000 1 5

**\*D3065-041\***

Step Leg Assembly Hi

\*\*

*B 77054*

*Ac 12.01.06*

Location

Loc Qty

Loc Code

WA

33

66149

0

76193

31

76194

2

*5*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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Parent Item: D350-591-312

**\*D350-591-312\***

Parent Item Name: Heli-Access-Step, Long RH

Start Date: 06/12/2011

Required Date: 30/01/2012

Start Qty: 5.00

Required Qty: 5.00

D3067-1 Manufactured No

180 Each 125.0000 1 5

**\*D3067-1\***

End Plate

\*\*

12.01.09

Location Loc Qty Loc Code

WA016 125  
67582 2  
68214 1  
75468 32  
76179 90

AN3-35A Purchased No

250 Each 145.0000 2 5

**\*AN3-35A\***

Bolt

\*\*

5

Location Loc Qty Loc Code

ST353 145  
117619 3  
119449 100  
119641 42

D3235-1 Manufactured No

250 Each 147.0000 2 10

**\*D3235-1\***

Mounting Lug

\*\*

10

Location Loc Qty Loc Code

ST481 147  
73411 47  
75547 100

D3278-041 Manufactured No

250 Each 62.0000 1 5

**\*D3278-041\***

Support Assembly

\*\*

12/1/17

Location Loc Qty Loc Code

ST481 62  
76169 35  
76170 27

5

W/O:		WORK ORDER CHANGES					
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Parent Item Name: Heli-Access-Step, Long RH

Start Date: 06/12/2011

Required Date: 30/01/2012

Start Qty: 5.00

Required Qty: 5.00

AN960JD416 NAS1149D0463J Purchased

No

250

Each

0.0000

16

80

**\*AN960.ID416\***

Washer

\*\*

ML19075

SD

AN960JD516 NAS1149D0563J Purchased

No

250

Each

0.0000

4

20

**\*AN960.ID516\***

Washer

\*\*

ML18206

SD

AN5-36A Purchased

No

250

Each

144.0000

2

10

**\*AN5-36A\***

Bolt

\*\*

SD

## Location

## Loc Qty

## Loc Code

ST340

144

118451

19

119449

50

119641

75

D2618

Manufactured

No

250

Each

152.0000

2

10

**\*D2618\***

Bushing

\*\*

## Location

## Loc Qty

## Loc Code

ST019

152

74458

52

76130

100

D2230-3

Manufactured

No

250

Each

99.0000

4

20

**\*D2230-3\***

Lug

\*\*

B76642

10/1/17 SD

## Location

## Loc Qty

## Loc Code

ST480

99

53881

4

70973

1

74440

10

75546

84

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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**\*D350-591-312\***

Parent Item Name: Heli-Access-Step, Long RH

Start Date: 06/12/2011

Required Date: 30/01/2012

Start Qty: 5.00

Required Qty: 5.00

D2856-400

Manufactured No

250 f

252.2445 1.2

6

**\*D2856-400\***

Abrasion Strip

\*\*

*sl*

Location

Loc Qty

Loc Code

ST409

252.2445

63735

0.6696

68076

0.3149

71164

37.86

73491

213.4

*6*

cut (2) D2856-400-720 as per dwg

MS21042L3

Purchased No

250 Each

7,467.000

2 10

**\*MS21042L3\***

Nut

\*\*

*sl*

Location

Loc Qty

Loc Code

ST300

87

117441

16

117885

35

118451

5

118927

31

ST516

5994

119017

5994

ST518

1385

119075

1385

*10*

AN4-13A

Purchased No

250 Each

980.0000

8

40

**\*AN4-13A\***

Bolt

\*\*

*12/1/17 sl SD*

Location

Loc Qty

Loc Code

ST357

980

118078

17

118838

363

119449

500

119798

100

*80*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Start Date: 06/12/2011

Required Date: 30/01/2012

Start Qty: 5.00

Required Qty: 5.00

MS21042L5

Purchased

No

250

Each

2,192.000

2

10

\*\*

\*MS21042I 5\*

Nut

## Location

## Loc Qty

## Loc Code

ST300

692

116105

5

116548

43

117611

52

118179

496

118910

96

ST518

1500

119109

1500

MS21042L4

Purchased

No

250

Each

10,136.00

8

40

\*\*

\*MS21042I 4\*

Nut

## Location

## Loc Qty

## Loc Code

ST300

526

117441

51

117601

342

118451

133

ST516

4605

119017

4605

ST518

5000

119075

5000

AN960JD10

NAS1149D0363J

Purchased

No

250

Each

0.0000

4

20

\*\*

\*AN960JD10\*

Washer

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



DESIGN <i>9P</i>	DRAWN BY <i>B</i>	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>CE</i>	APPROVED <i>H</i>	DRAWING NO. D3272	REV. B SHEET 1 OF 3
DATE 07.05.18		TITLE STEP ASSEMBLY, HI LONG	SCALE NTS
A	04.03.01	NEW ISSUE	
B	07.05.18	D3272-1 WAS D2622-120	

**RELEASED**

*07.06.04*

QTY -041	QTY -042	PART NUMBER	DESCRIPTION
X		D3272-041	STEP ASSEMBLY, HIGH LONG (LH)
	X	D3272-042	STEP ASSEMBLY, HIGH LONG (RH)
1	1	D3065-041	LEG ASSEMBLY
2	2	D3066-1	SPACER
2	2	D3067-1	END PLATE
2	2	D3219-1	SUPPORT
1	1	D3272-1	STEP
16	16	MS20600AD4W4	RIVET

**GENERAL NOTES:**

- 1) D3272-041 SHOWN. FOR D3272-042, INSTALL D3219-1 SUPPORT OPPOSITE SIDE
- 2) WELD PER DART QSI 004
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005.4.1  
POWDER COAT ASSEMBLY WHITE (4.3.5.1) PER DART QSI 005 4.3  
BLACK ANTI-SKID PAINT PER DART QSI 005 4.4
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED.
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX.

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER

NO. 77357 M.C.J

*11/12/06*

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# Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

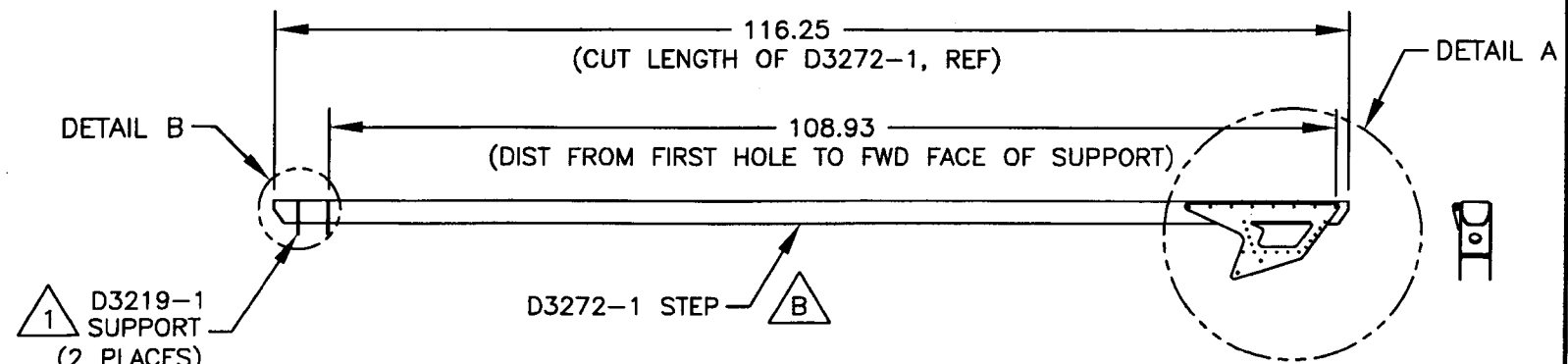
Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

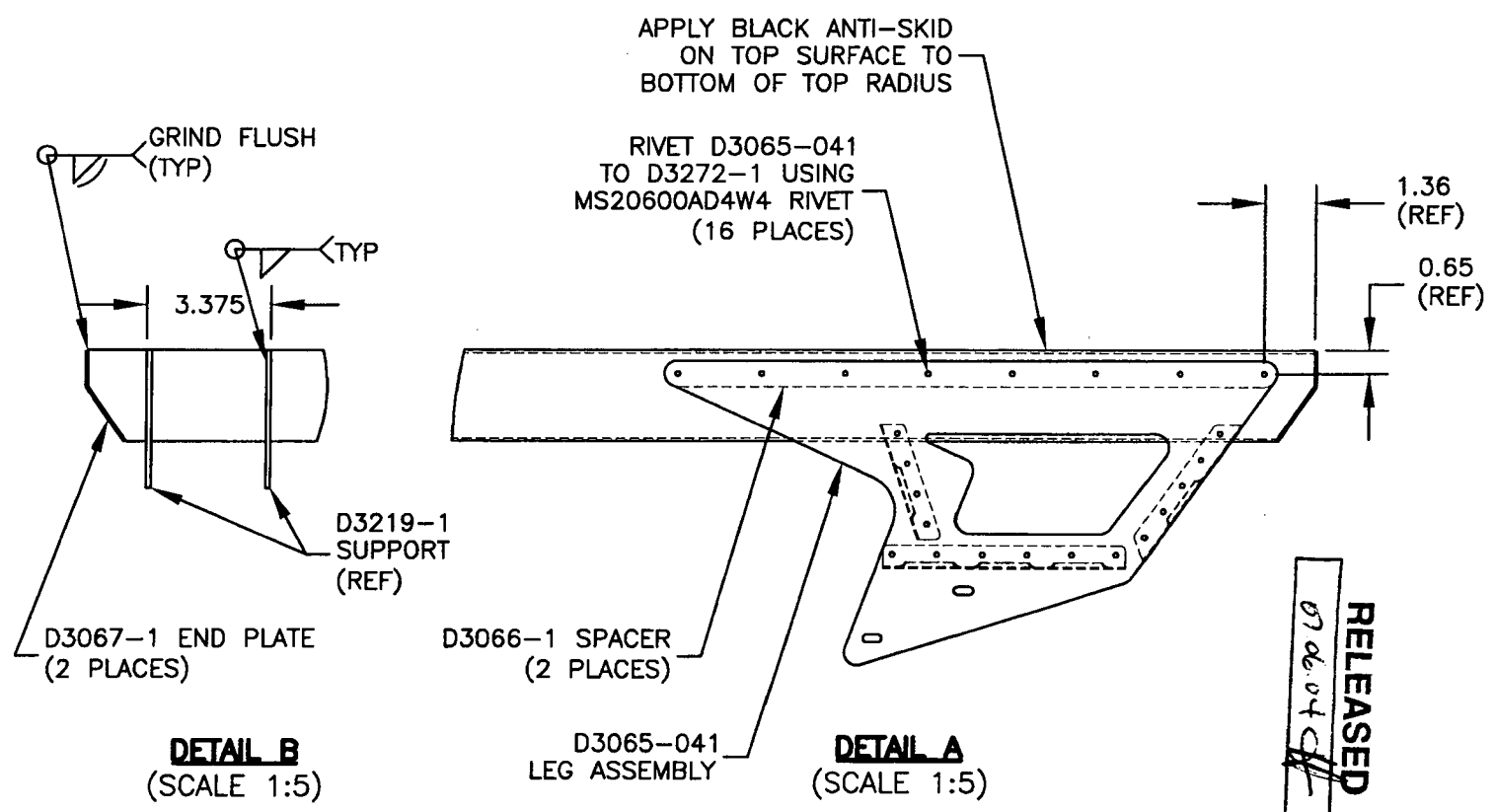
NOTE: Date & initial all entries

77357

**DART**



**D3272-041 STEP ASSEMBLY (LH. SHOWN)**  
**D3272-042 STEP ASSEMBLY (RH, OPPOSITE)**



DESIGN	AP	DRAWN BY	JR	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED	CE	APPROVED	[Signature]	DRAWING NO. D3272
DATE	07.05.18	TITLE	STEP ASSEMBLY, HI LONG	REV. B
		SCALE	1:20	SHEET 2 OF 3

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

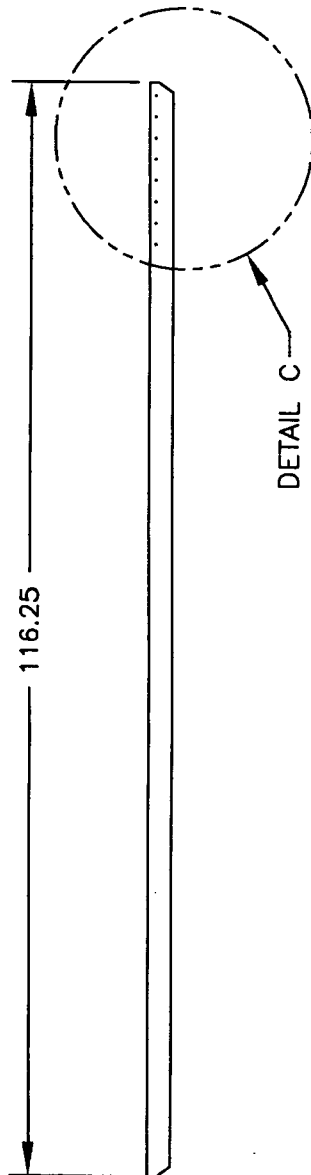
**NOTE:** Date & initial all entries



DESIGN <i>qp</i>	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>LE</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3272	REV. B SHEET 3 OF 3
DATE 07.05.18		TITLE STEP ASSEMBLY, HI LONG	SCALE 1:20

RELEASED

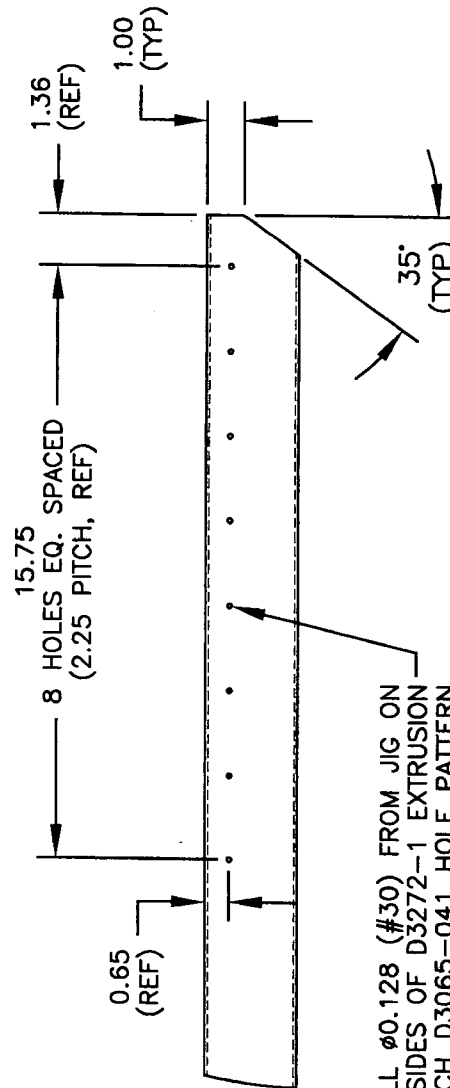
07.06.04 *[Signature]*



DETAIL C

**B D3272-1 STEP**

(MAKE FROM D2622-120 STEP EXTRUSION)



DRILL  $\phi 0.128$  (#30) FROM JIG ON BOTH SIDES OF D3272-1 EXTRUSION TO MATCH D3065-041 HOLE PATTERN

**DETAIL C**  
(SCALE 1:5)

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



Qty -211	Qty -212	Qty -213	Qty -214	Qty -215	Qty -216	Qty -311	Qty -312	Part Number	Description
X								D350-591-211	Heli-Access-Step™, Long Step – High Skid, LH
	X							D350-591-212	Heli-Access-Step™, Long Step – High Skid, RH
		X						D350-591-213	Heli-Access-Step™, Short Step – High Skid, LH
			X					D350-591-214	Heli-Access-Step™, Short Step – High Skid, RH
				X				D350-591-215	Heli-Access-Step™, Short Step – Low Skid, LH
					X			D350-591-216	Heli-Access-Step™, Short Step – Low Skid, RH
						X		D350-591-311	Heli-Access-Step™, Long Step – High Skid, LH
							X	D350-591-312	Heli-Access-Step™, Long Step – High Skid, RH
1								D3070-041	STEP ASSEMBLY (HIGH-LONG, LH)
	1							D3070-042	STEP ASSEMBLY (HIGH-LONG, RH)
		1						D3078-041	STEP ASSEMBLY (HIGH-SHORT, LH)
			1					D3078-042	STEP ASSEMBLY (HIGH-SHORT, RH)
				1				D3168-041	STEP ASSEMBLY (LOW-SHORT, LH)
					1			D3168-042	STEP ASSEMBLY (LOW-SHORT, RH)
						1		D3272-041	STEP ASSEMBLY (HIGH-LONG, LH)
							1	D3272-042	STEP ASSEMBLY (HIGH-LONG, RH)
4	4							D2182B035	RUBBER CUSHION
		2	2	2	2			D2230-1	MOUNTING LUG
		2	2	2	2	4	4	D2230-3	MOUNTING LUG
8	8							D2274	RADIUS BLOCK
						2	2	D2618	BUSHING
4	4	4	4	4	4			D2732-030	*CUSHION
2	2	1	1	1	1	2	2	D2856-400-720	ABRASION STRIP
2	2							D3064-1	CLAMP
1	1							D3079-041	SUPPORT ASSEMBLY
4	4							D3080-1	CLAMP
						2	2	D3235-1	MOUNTING LUG
						1	1	D3278-041	SUPPORT ASSEMBLY
2	2	2	2	2	2	2	2	AN3-35A	BOLT
10	10	2	2	2	2			AN4-11A	BOLT
		4	4	4	4	8	8	AN4-13A	BOLT
						2	2	AN5-36A	BOLT
4	4	4	4	4	4	4	4	AN960JD10	WASHER
20	20	12	12	12	12	16	16	AN960JD416	WASHER
						4	4	AN960JD516	WASHER
2	2	2	2	2	2	2	2	MS21042L3	NUT
10	10	6	6	6	6	8	8	MS21042L4	NUT
						2	2	MS21042L5	NUT
						1	1	*DSI 9410-011	STEP MODIFICATION KIT

\*DSI 9410-011 Step Modification Kits are provided with all D350-591-311 and D350-591-312 Steps. This kit is provided as an option for the installer and is therefore **NOT REQUIRED** to complete the installation of the D350-591-311 or D350-591-312 Steps. Refer to Figure 21 for installation of the DSI 9410-011 Kit.